

# Work Order ID 56853

March 11, 2010 7:37:24 AM

Page 1

Item ID: D3695-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Stopper

Start Date: 3/11/10 Start Qty: 600

Cust Item ID:

Required Date: 3/15/10 Req'd Qty: 600

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3695

Rev C

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank 4.25 " long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1- Mill as per Folio FA733 Rev: AA & Dwg D3695 Rev: C 112-Deburr  
per dwg D3695 113-TAP FOR 3/8"-24 HELICOIL

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56853

March 11, 2010 7:37:24 AM



Page 2

Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 3/11/10

Start Qty: 4.00



Cust Item ID:

Required Date: 3/15/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

\*\*\*\*\*MASK ALL HOLES AS PER DWG

D3695\*\*\*\*\*[START TIME:

9:15am OVEN TEMPERATURE: 9:45am FINISH

TIME: 370°F

ack 10/03/15

6 0

BR 10-3-15

6 0

=> 10/03/16

(X6) 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 56853

March 11, 2010 7:37:25 AM



Page 3

Item ID: D3695-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Stopper

Start Date: 3/11/10

Start Qty: 4.00



Cust Item ID:

Required Date: 3/15/10

Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

BR 10-3-16

⑥ ①

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: 255

0.00

Memo

0.00

10-3-18

⑥ ①

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/24

CL 10/3/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

March 11, 2010 7:37:23 AM

Page 1

Work Order ID: 56853



Parent Item: D3695-3



Parent Item Name: Stopper

Start Date: 3/11/10

Required Date: 3/15/10

Comments: IPP Rev:A 08-03-27 new issue DD verified by:JLM

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.500X03.50 0		Purchased	No				f	33.0343	1.4807			



6061-T6 Bar 2.50 x 3.50

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

33.03425

102838

13.1

110936

1.03

111700

1.365

113403

17.53925

*10-3-11*

*~~2.125~~ 2.125'*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 50853
<b>Description:</b> Slider		<b>Part Number:</b> D3695-3
<b>Inspection Dwg:</b> D3695 <b>Rev:</b> C		<b>Page</b> 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

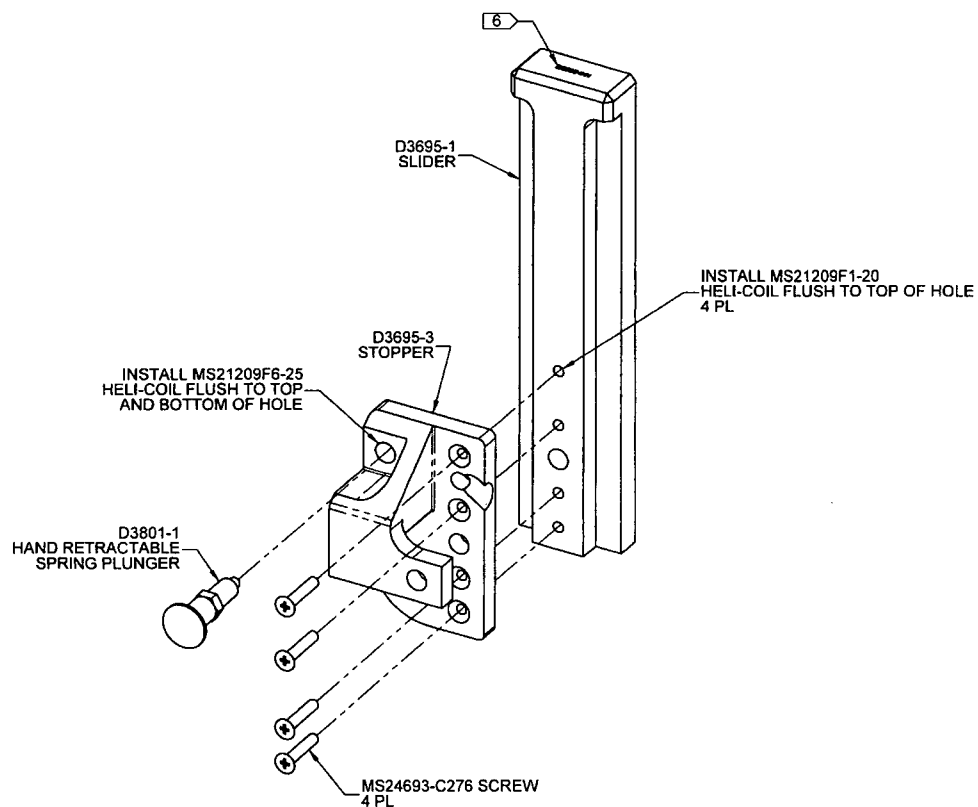
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.625	+/-0.010	0.623	✓			
1.063	+/-0.010	1.063	✓			
Ø0.391	+0.006/-0.001	Ø0.393	✓			
Ø0.194	+0.005/-0.001	Ø0.196	✓			
Ø0.425 x 100°	+/-0.010 x 0.5°	Ø0.423 x 100°	✓			
Ø0.386	+0.006/-0.001	Ø0.388	✓			
0.450	+/-0.010	0.450	✓			
2.025	+/-0.010	2.026	✓			
0.83	+/-0.010	0.830	✓			
0.575	+/-0.010	0.575	✓			
0.500	+/-0.010	0.500	✓			
Ø0.328	+0.006/-0.001	Ø0.330	✓			
0.500	+/-0.010	0.502	✓			
1.813	+/-0.010	1.815	✓			
2.62	+/-0.030	2.622	✓			
1.075	+0.010/-0.000	1.079	✓			
0.38	+/-0.030	0.375	✓			
2.313	+/-0.010	2.318	✓			
4.00	+/-0.030	4.000	✓			
1.83	+/-0.030	1.831	✓			
1.23	+/-0.030	1.222	✓			
2.25	+/-0.030	2.250	✓			
0.650	+/-0.010	0.651	✓			
0.279	+/-0.010	0.277	✓			

<b>Measured by:</b> H.A	<b>Audited by:</b> [Signature]	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 10/03/13	<b>Date:</b> 10/03/15	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ [Signature]	[Signature]

8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW



**D3695-041 SLIDER ASSEMBLY**

**D3695-041 NOTES:**

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3695-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: D3695-041 = 0.64 lbs

56853 **RELEASED**  
9/6/03

C	UPDATED BOM TO CURRENT STANDARDS; REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 <sup>DATE</sup> WERE 1.81 AND 1.083 <sup>DATE</sup> (ZN B6-3 AND C4-3); REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.28
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.11.04		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3695** REV. C  
SHEET 1 OF 3  
TITLE **SLIDER ASSEMBLY** SCALE NTS

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8 7 6 5 4 3 2 1

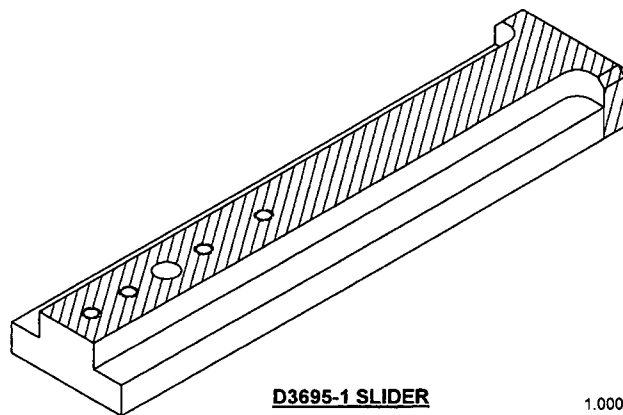
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

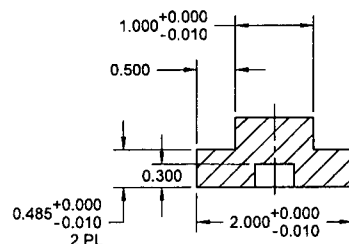
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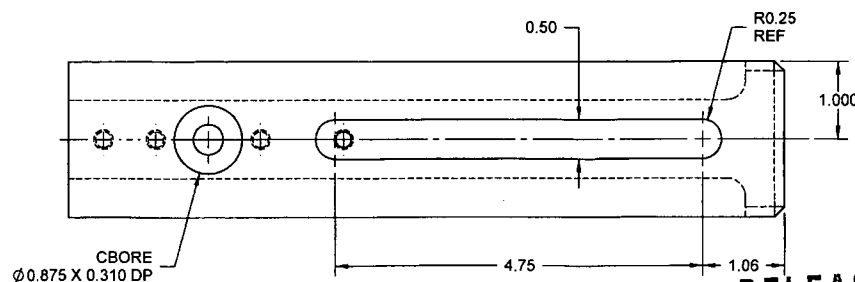
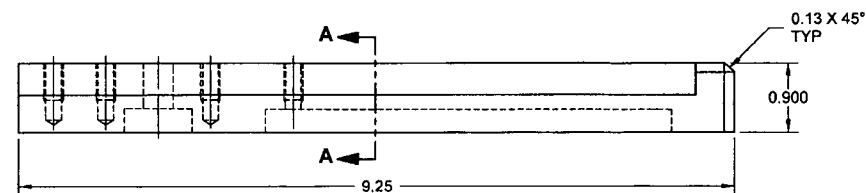
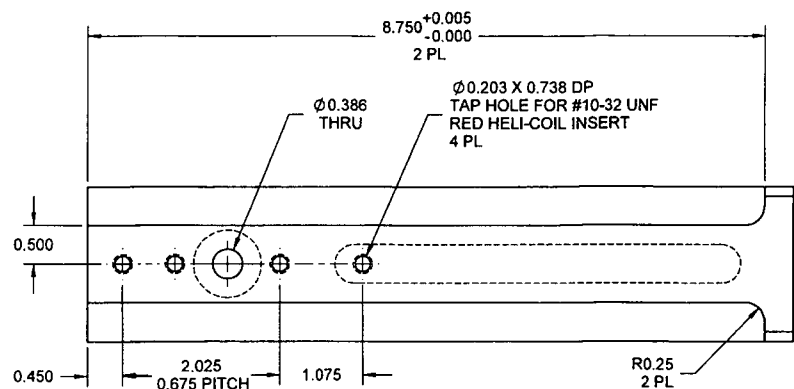
**NOTE:** Date & initial all entries



**D3695-1 SLIDER**



**SECTION A-A**



**D3695-1 NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART  
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

*56853*

**RELEASED**  
*09/02/05*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3695</b>	REV. C
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE <b>SLIDER ASSEMBLY</b>	SCALE
DE APPR.			NTS
DATE	08.11.04	COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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